

1/13

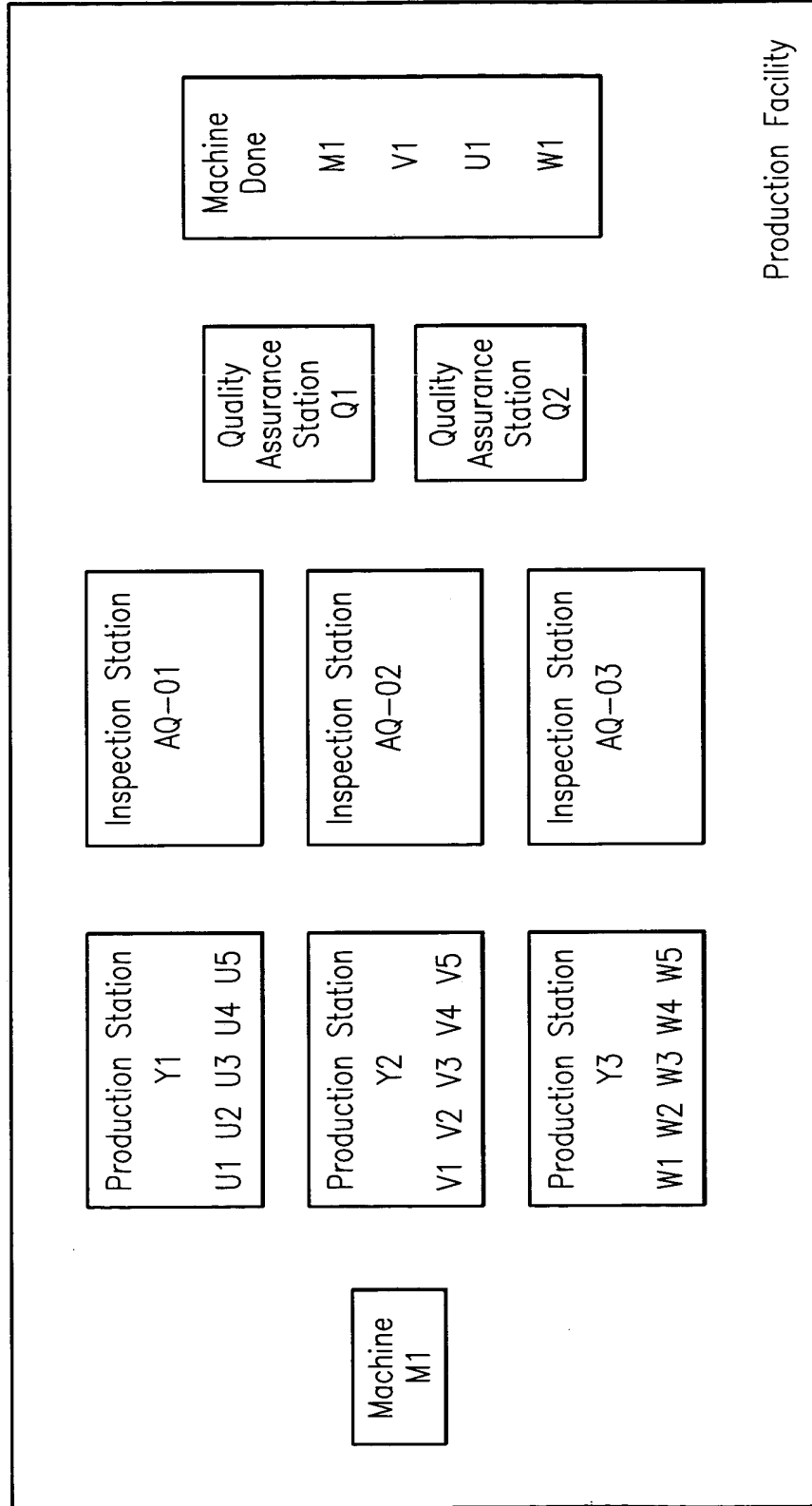
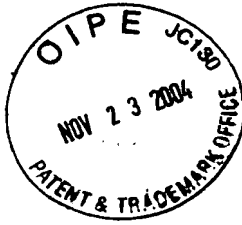


FIG. 1



2/13

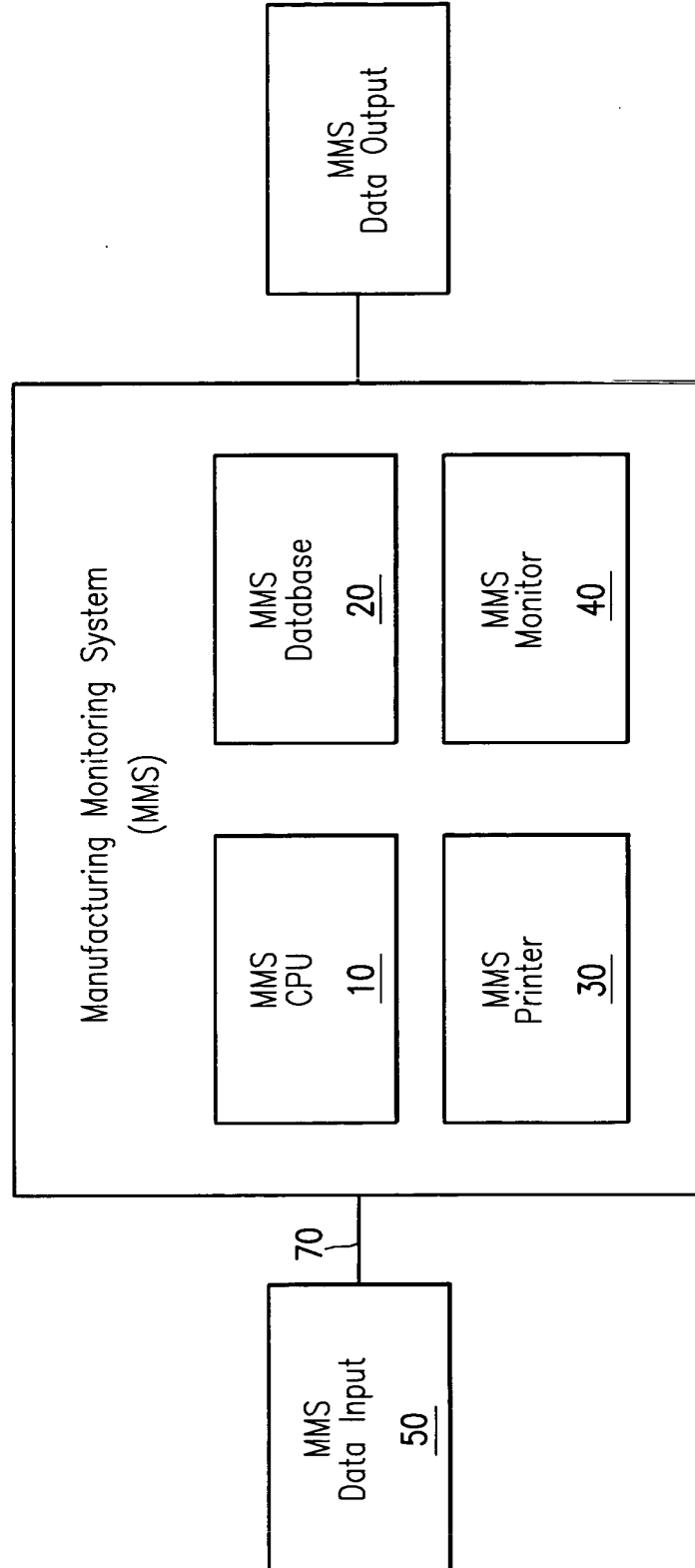


FIG. 2



3/13

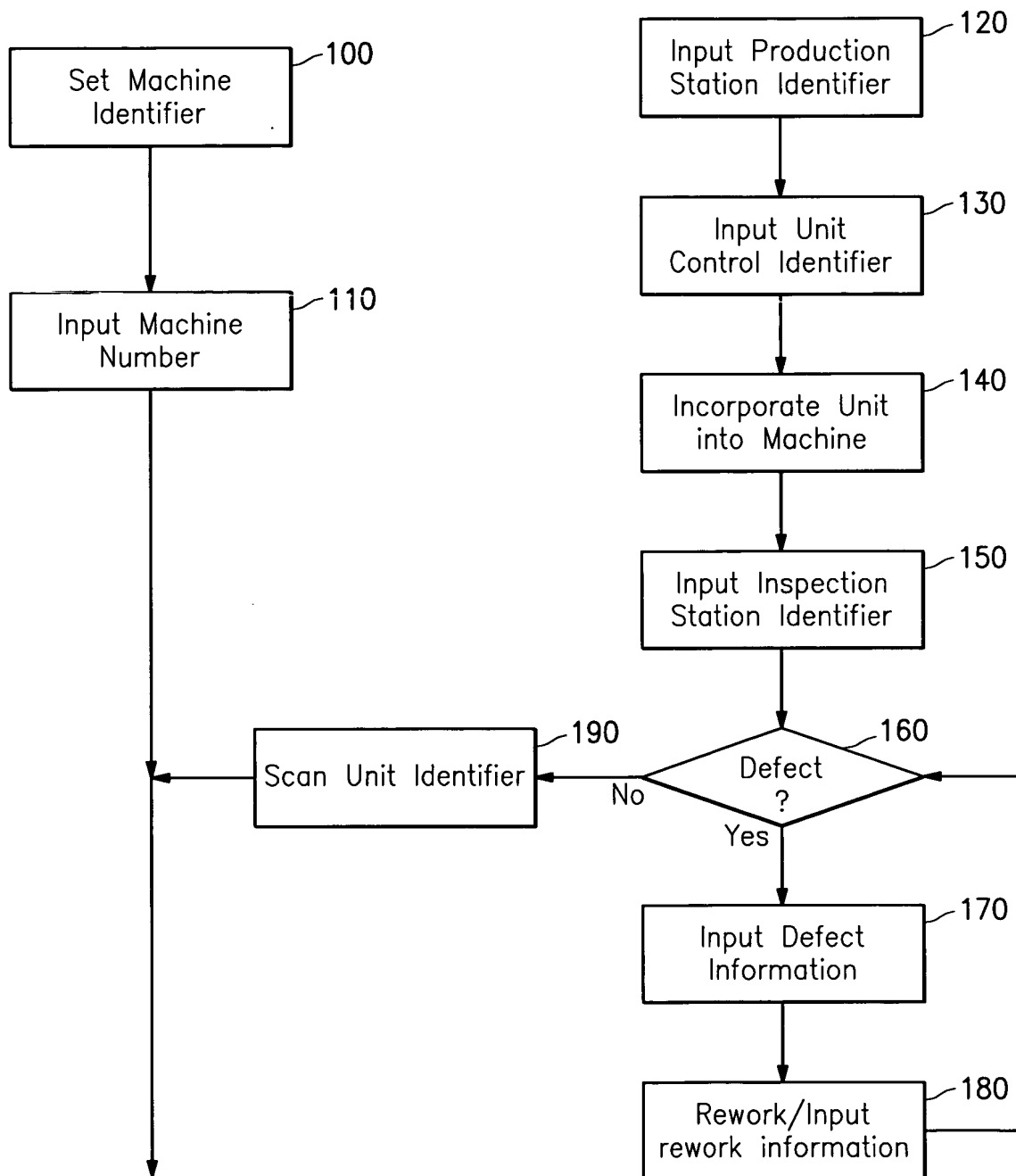


FIG. 3



4/13

192

Serial No.

Machine No.

QA Insp.Name  Inspection Date

Alicia - 00073  
Ellen - 02120  
Em - 01945  
Heriberta - 00369  
Rita - 00406  
Rosa - 02365  
Socorro - 00461  
Victor - 04508

Log on

Log off

Exit

Date  X

Month

List All QA Insp. Mach.

List All QA defect

Print Out Traveler

191

193

Insp.Station

Employee #

Defect Time

Defect

Grade

Repair

Responsible

TTR Name

Insp.Recheck Name

Note

194

195

197

196

199

188

198

FIG. 3A



U.S. Serial No.: 9/827,507  
Filing Date: April 6, 2001  
Title: APPARATUS AND METHOD FOR MONITORING  
MANUFACTURING STATUS  
Inventor(s): Tri Minh Nguyen  
Hogan & Hartson Docket No.: 81855.0008  
Replacement Sheet

5/13

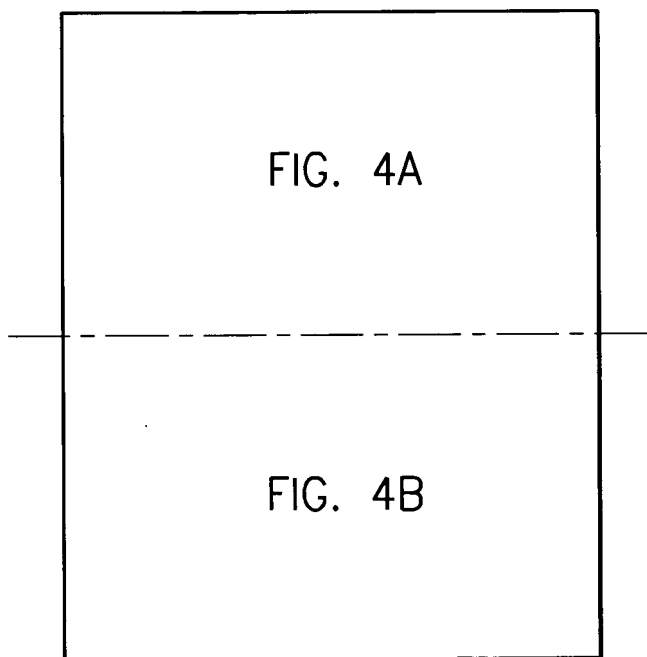


FIG. 4

# FIG. 4A



U.S. Serial No.: 9/827,507  
 Filing Date: April 6, 2001  
 Title: APPARATUS AND METHOD FOR MONITORING  
 MANUFACTURING STATUS  
 Inventor(s): Tri Minh Nguyen  
 Hogan & Hartson Docket No.: 81855.0008  
 Replacement Sheet

A229-17 120V-60Mz		Traveler - Machine Record		Ricoh Aficio650	
MACHINE NUMBER		MACHINE Serial #			
2299110042		 A 22 917 00 00 00 00 00 00 y			
AU-01	Scanner BICU PCB Serial # Duplex Unit No. Scanner Unit No.	Machine Input Date/Time 11/1/99 11 27:15 AM		Machine Output Date/Time	
AU-02	Fusing Unit No. Controller Unit No. PCU Unit No.	ARDF Serial No.		Beam Pitch  0 8 8 7 3 6 0	
AU-03	Trandem LCT User No. Operation Panel PCB Serial No.	PCI Nos.		Beam Power  9 1 3 0 7 8	
AQ-01	I/O PCB Serial # Power Supply PCB Serial # Paper Bank PCB Serial # Ground Test Insulation Test	Back Front Upper Lower		Slave Developer Tank Voltage #  0 0 7 1 1 1 J	
AQ-02	Leakage Test Total Wattage	49040107 49034179 49047500 (yes) (no) (yes) (no) 10 MOhms or More 3.5 mA Max 1300~1500 Watts		Operation Panel PCB Serial # Paper Feed Unit No. Exit Unit No.	
AQ-03	Total Counter	0000000001~0000010			
AQ-04	High Voltage Test Ground Test	1.25 KV for 2 seconds 0.1 Ohm or Less (yes) (no) (yes) (no)			

6/13

240

250

260

230

200

210

220



U.S. Serial No.: 9/827,507  
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 MANUFACTURING STATUS  
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 Replacement Sheet

7/13

QA Defect											QA
Defect											TIR
Repair											QA
AQ-01											AQ-09
AQ-02											AQ-10
AQ-03											QA
AQ-04											
AQ-05											
AQ-06											
AQ-07											
AQ-08											
AQ-09											
AQ-10											
Note											
DEFECT											OFF LINE
REPAIR											TIR
STA											INSP
											OUT
											IN
											OUT
											IN
											OUT
											IN
											OUT
											IN
											OUT
											IN
											OUT
											IN
											OUT
											IN

FIG. 4B



8/13

## Current Data (From Last Working Day 4:00 PM to Today 4:00 PM)

### QC Stations

	Def	Insp	Rate	
AQ-01	14	88	0.159	III
AQ-02	6	87	0.069	III
AQ-03	6	85	0.071	III
AQ-04	0	85	0	III
AQ-05	2	83	0.024	III
AQ-06	0	86	0	III
AQ-07	2	85	0.024	III
AQ-08	3	84	0.036	III
AQ-09	1	84	0.012	III
AQ-10	1	84	0.012	III
AU-01	2	88	0.023	III
AU-02	3	76	0.04	III
AU-03	3	75	0.04	III
	300	310	320	330

X

All Models

Total Defect  395

NIC Defect  390

Insp.Q'ty  380

Failer Rate  370

Refresh to  
Latest Data

Return to  
Main Screen

Q'ty Rate

Prod Main   III

Prod Sub   III

J-7   III

Loc   III

PCB   III

Eng   III

QC   III

No Info   III

Others   III

Under Rework   III

340 350 360

FIG. 5





U.S. Serial No.: 9/827,507  
 Filing Date: April 6, 2001  
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 MANUFACTURING STATUS  
 Inventor(s): Tri Minh Nguyen  
 Hogan & Hartson Docket No.: 81855.0008  
 Replacement Sheet

9/13

Machine No.	Insp St	Defect	Repair	Respons	Prod	Defect Time
9350050200	AQ-01	Discn cn(2)pin rear mach Fan	Connected	PROD	AE LINE	5/30/00 7:55:36AM
9350050168	AQ-01	Discn cn(273): Paper bank board	Connected the connector	PROD	AE-07	5/25/00 4:53:37PM
9350050177	AQ-01	Harness out of the saddle rear side mach base	Put into the clamp	PROD	AE-02	5/25/00 4:03:44PM
9350050254	AQ-01	Incomplete locked Ferrite Cote	Assy closed (ferrite)	PROD	AC LINE	5/30/00 2:01:58PM
9350050238	AQ-01	Loose rivet: paper bank frame	Retighten	PROD	AW LINE	5/30/00 12:50:25PM
9350050220	AQ-01	M/M Duct fan	Remounted	PROD	AC-05	5/30/00 10:01:01AM
9370050011	AQ-01	M/S ferrite power cord				5/30/00 3:32:19PM
9350050252	AQ-01	M/S screw, Duct fan				5/30/00 3:24:30PM
9350050252	AQ-01	M/S screw, Duct fan(1)	Installed (SCREW)	PROD	AC-01	5/30/00 1:25:52PM
9350050202	AQ-01	M/S screw, Duct fan brkt (1)	Installed the screws	PROD	AE-11	5/30/00 8:11:51AM
9350050248	AQ-01	M/S toner recycle brkt. Screws on rear side	PTA #9 error (installed the saddles)	PROD	AE-02	5/30/00 1:01:58PM
9350050243	AQ-01	Mis-routed black han. Power supply	Assy put correct position(harness)	PROD	AE-LINE	5/30/00 12:37:00PM
9350050177	AQ-01	No display: operation panel	Replace BICU replaced	J-7		5/30/00 4:04:34PM
9350050233	AQ-01	No display: operation panel	Replace scanner PCB	J-7		5/30/00 11:12:52AM
9350050209	AQ-01	No power: machine	BICU CN-301 disconnect(connected)En	PROD	AE-10	5/30/00 9:24:40AM
9350050205	AQ-01	SC 366 light stay on	Replaced BICU pcb	J-7		5/30/00 8:24:02AM
9350050252	H4805300240	AQ-01 MS Screw Doct		05-30-00 3:24PM	05-30-00	8:57 AM
9350050252	H4805300240	AQ-09 Out prime temp scanner harness		05-30-00 3:23PM	05-30-00	8:57 AM
Record	8165	8165	or 8165			

FIG. 6



10/13

500

Production

AA-Line

AB-Line

AC-Line

AD-Line

AE-Line

AF-Line

AG-Line

Total

Main

Sub

AT-Line

AW-Line

510

Defect Analysis

Date

05-30-00

Month

May-00

DailyDefect

Eng.

Other

No Info.

No Charge

Part

In-House

WareHouse

Local

J-7

PCB

Paint

Press

Mold

Handling

Issue

Return to Main Screen

DAILY MOJITO Failure Rate

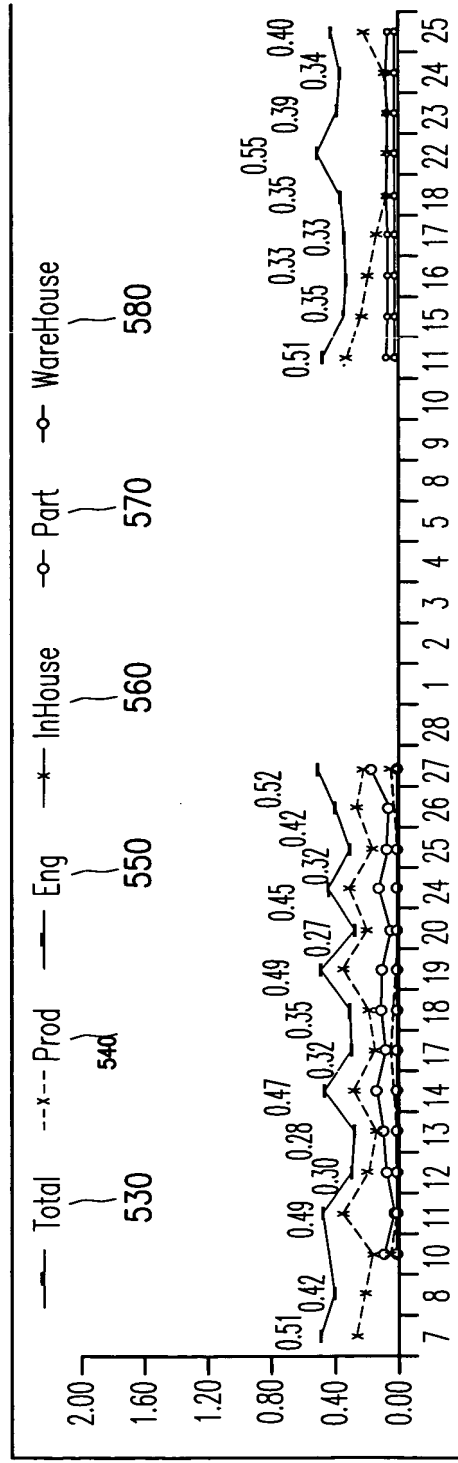


FIG. 7



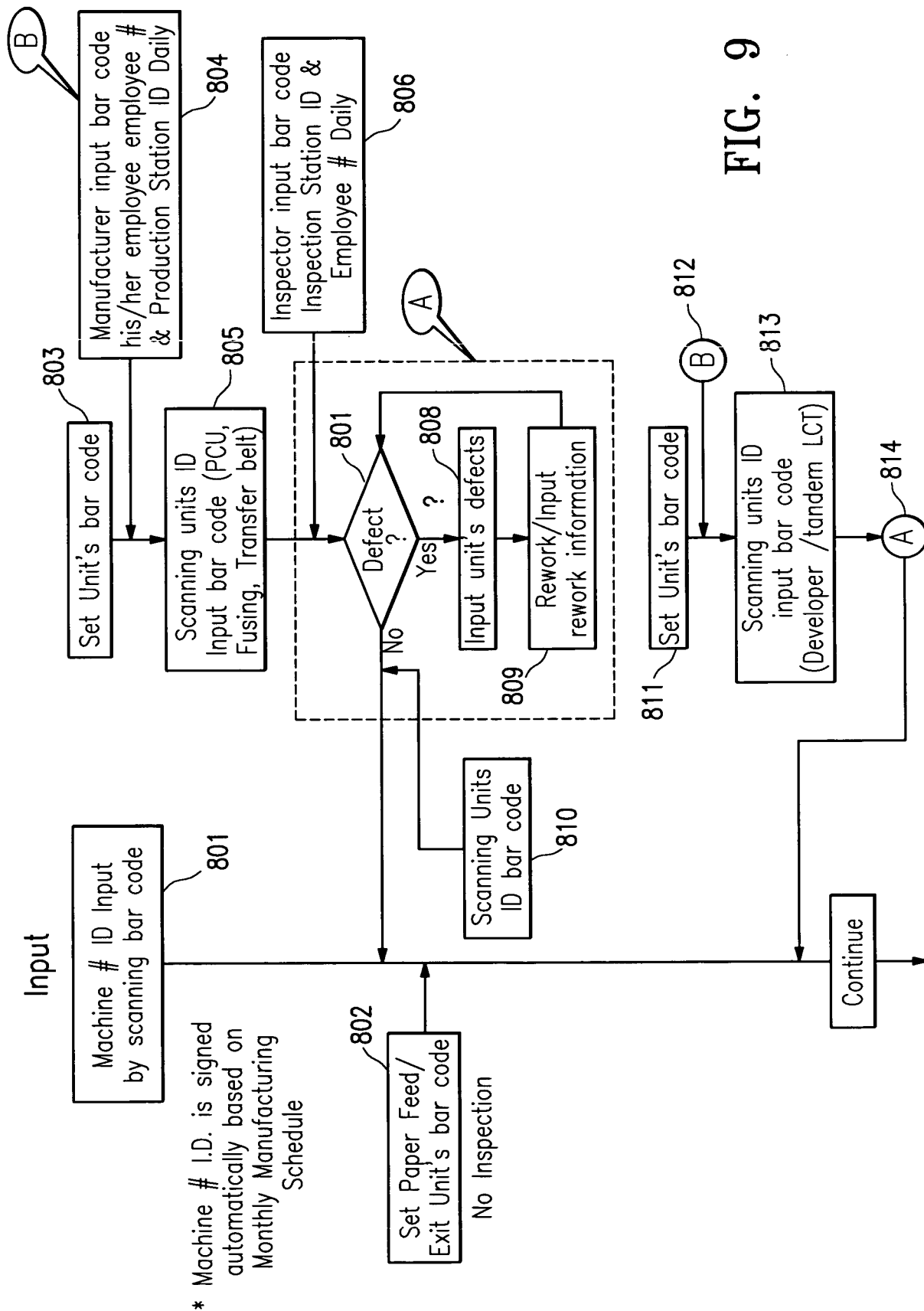
11/13



Date	Input			QC Output			Packing Output			Work in Progress			Total		
5/25/00	95			95	93	93			101			82	0	82	△
5/24/00	95			95	100	100			102			88	0	88	
5/23/00	96			96	105	105			115			95	0	95	
5/22/00	82			82	78	78			57			114	0	114	
5/18/00	94			94	85	85			86			89	0	89	
5/17/00	91			91	87	87			115			81	0	81	
5/16/00	94			94	90	90			60			105	0	105	
5/15/00	86			86	90	90			94			71	0	71	
5/11/00	93			93	85	85		5	82			79	0	79	
5/10/00	66	7		73	7	68		74	1			68	5	73	
5/9/00		91		91		85		84				3	72	75	
5/8/00		73		73		70		81				3	65	68	
5/5/00		62		62		64		63	1			3	73	76	▽



12/13





13/13

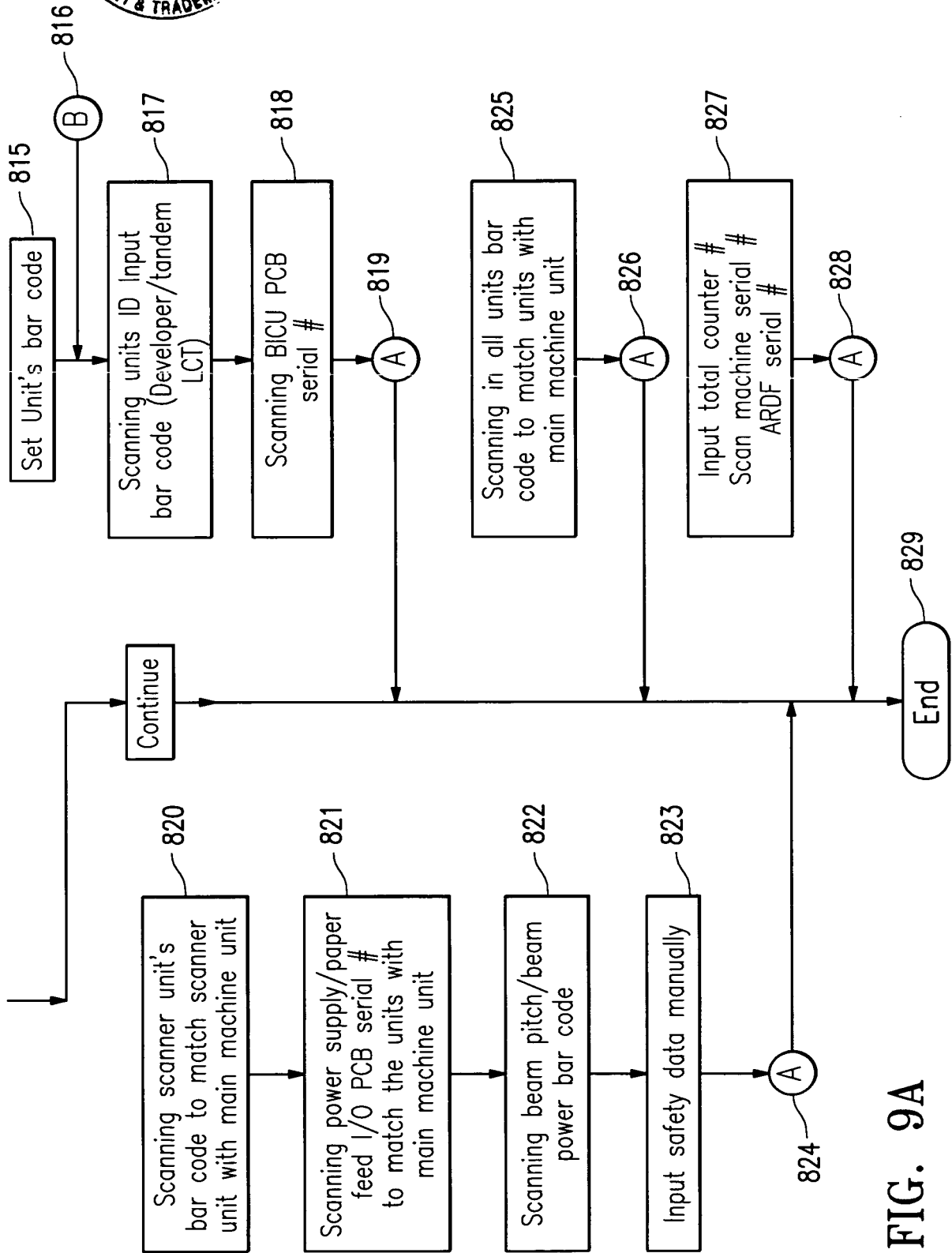


FIG. 9A